

Date: Wednesday, 5/3/2006 11:50:04 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT GUSSET (350) BASKET
Job Number : 26922	
Estimate Number : 10496	
P.O. Number : N/A	Part Number : D2325
This Issue : 5/3/2006 S.O. No. : N/A	Drawing Number : D2325 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 26922	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 5/10/2006 Qty: 20 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	
Comment : Est. D 02.12.06 Reformat; Rev B KJ/RF Est. E06.05.03 Water jet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.4883 sf(s)/Unit Total : 9.7650 sf(s)
 304/316 SS .063 Sheet Batch: M7106

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2325
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

H.M 06-05-03

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M

06 05 03

(20)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

06 05 03

(20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

H.M 06-05-03

(20)

Date: Wednesday, 5/3/2006 11:50:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 26922

Part Number: D2325

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-05-03

20

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE#1



06-05-03

20

Comment: PACKAGIN

Identify and Stock

Location: WS

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-05-04

20

Job Completion



06-05-04

Date: Wednesday, 5/3/2006 8:25:27 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT GUSSET (350) BASKET
Job Number : 26922	
Estimate Number : 10496	
P.O. Number :	Part Number : D2325
This Issue : 5/3/2006 S.O. No. :	Drawing Number : D2325 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 26741	Material :
Written By :	Due Date : 5/10/2006 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est. D 02.12.06 Reformat; Rev B KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

Email or ship DXF file to vendor Make as per Dwg D2325.

Material: 304 SS .063" Thick

Material release note required

2.0	D2325F	Support Gusset (350 Bask
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M304S16GA

0.465 SS



Comment: Qty: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Gusset (350 Bask

date:

3.0	PACKAGING 1 Water	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/3/2006 8:25:27 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 26922

Part Number: D2325

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

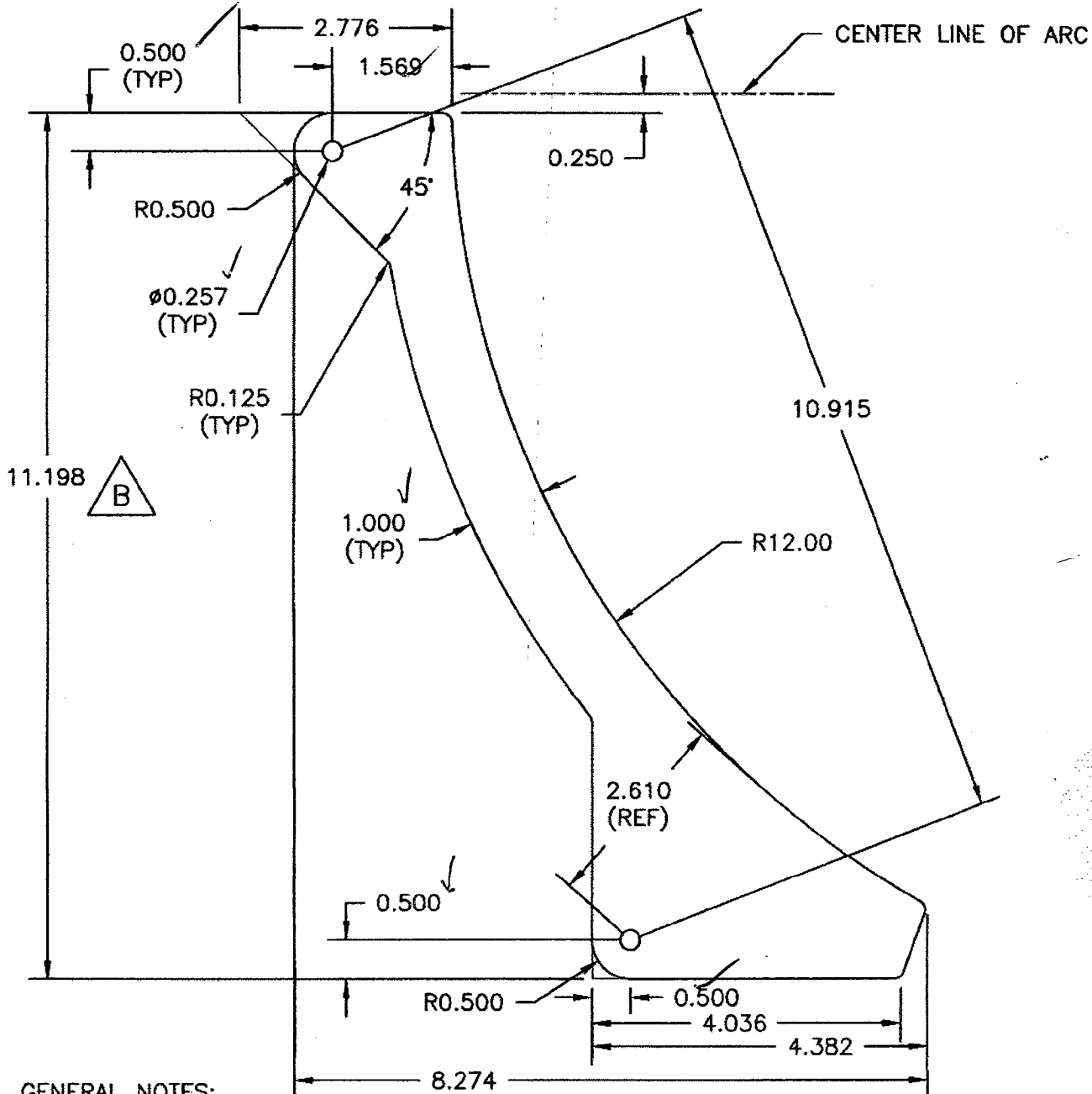
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2325	REV. B SHEET 1 OF 1
DATE 02.08.28		TITLE SUPPORT GUSSET	SCALE 1:2
A	94.12.13	NEW ISSUE	
B	02.08.28	REFORMAT; 11.198 WAS 11.948	

RELEASED
02.08.29



GENERAL NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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